

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021132**Date Inspected:** 07-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment12CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint OBE12CE-005 located on Cross Beam side Drain Plate. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1.

OBG Segment 12AE

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Cross Beam side SP temporary attachment removed & base metal repaired area. See attached photograph Pic_001.

Bay 16/OBG 13AW Assy

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld joint LD3034-001-082 located on OBG Segment 13AW lifting Bracket. The welder is identified as 021583. ABF Quality Assurance (QA) is identified as Li Shi You. The welding variables recorded by QC appeared to comply with the WPS B-T-2233-TC-U5-F. See attached photograph Pic_002.

OBG Lift 10E Bike Path Cantilever

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as Lift 10E Cantilever & floor beam as per ZPMC notification # 06881 items # 2 to 7.

The weld designations reviewed are as follows:

Item # 2 BK001-PP97-005, 007, 009

Item # 3 FB014-040-053, 054, 055

Item # 4 BK001-PP95-005, 007, 009

Item # 5 BK001-PP91-005, 007, 009

Item # 6 BK001-PP89-005, 007, 009

Item # 7 BK001-PP93-005, 007, 009



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer